

Date: Thursday, 7/19/2007 2:28:00 PM
 User: Kim Johnston

Process Sheet

| | |
|--|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : DOOR |
| Job Number : 33677 | |
| Estimate Number : 12954 | |
| P.O. Number : <u>N/A</u> | Part Number : D32597 |
| This Issue : 7/19/2007 S.O. No. : <u>N/A</u> | Drawing Number : D3259 REV A1 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <u>N/A</u> Type : SMALL /MED FAB | Drawing Revision : A1 |
| Previous Run : <u>N/A</u> | Material : <u>N/A</u> |
| Written By : <u>[Signature]</u> | Due Date : 8/10/2007 Qty: 4 Um: Each |
| Checked & Approved By : <u>[Signature]</u> 07.07.19 | |
| Comment : Est Rev: A New Issue 07-07-19 JLM Verified By: | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M2024T3S063 | 2024-T3 .063 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 1.4574 sf(s)/Unit Total : 5.8296 sf(s)

2024-T3 .063 sheet

Batch: M101422

Scrap = 5

M104921 =

HB 07-07-26

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3259

Dwg Rev: A1

Prog Rev: A1

HB 07-07-26

2-Deburr if necessary

SAW 07/07/26

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



HB 07-07-26

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

En 07/07/26

| | | |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

0707-31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/07/26

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|-----------------------------|------------------------------------|--------------------------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07-07-26 | 2.0 | Scrap 1 piece HAD TO CHANGE OFFSET | <i>[Signature]</i> | Scrap, destroy, replace | 07-07-26 <i>[Signature]</i> | Ep 07/07/26 | <i>[Signature]</i> | Ep 07/07/26 |
| 07.07.26 | 2.0 | Scrap 4 pieces w/o had 2 different material thickness | <i>[Signature]</i> | Scrap, destroy, replace fix w/o | 07-07-26 <i>[Signature]</i> | Ep 07/07/26 | <i>[Signature]</i> | Ep 07/07/26 |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:28:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR

Job Number: 33677

Part Number: D32597

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten signature and date: 07/08/01 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Handwritten signature and date: 07/08/01 (4)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten date: 07/08/03 (4)

Job Completion



Handwritten date: 07-08-01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

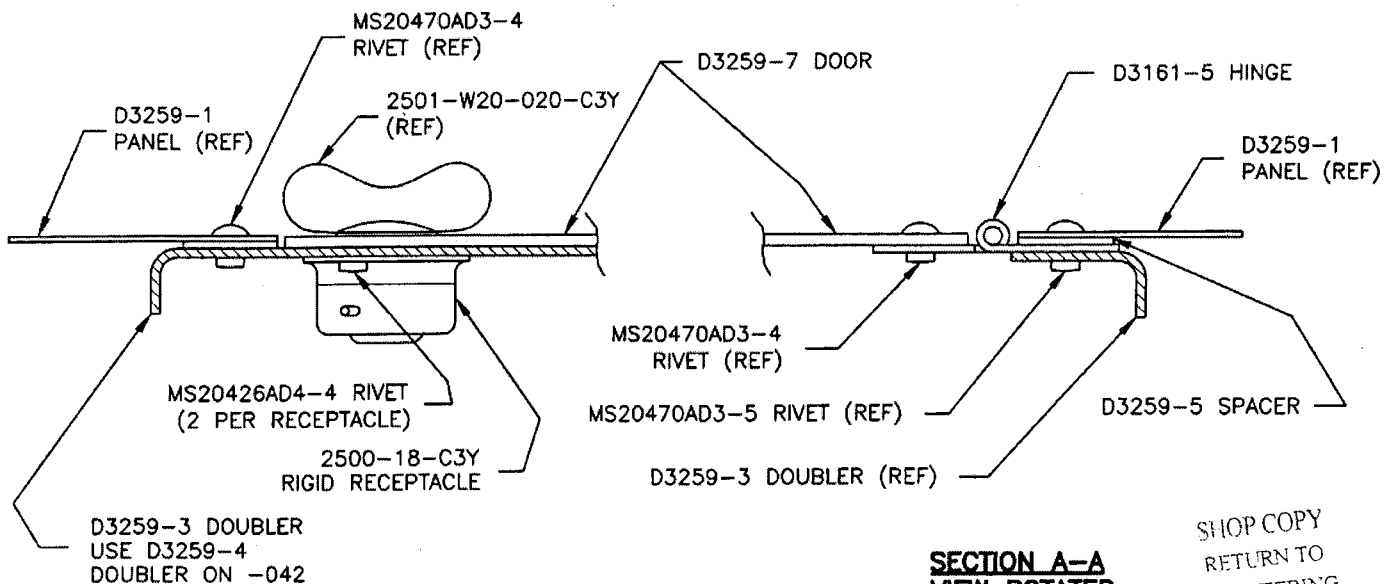
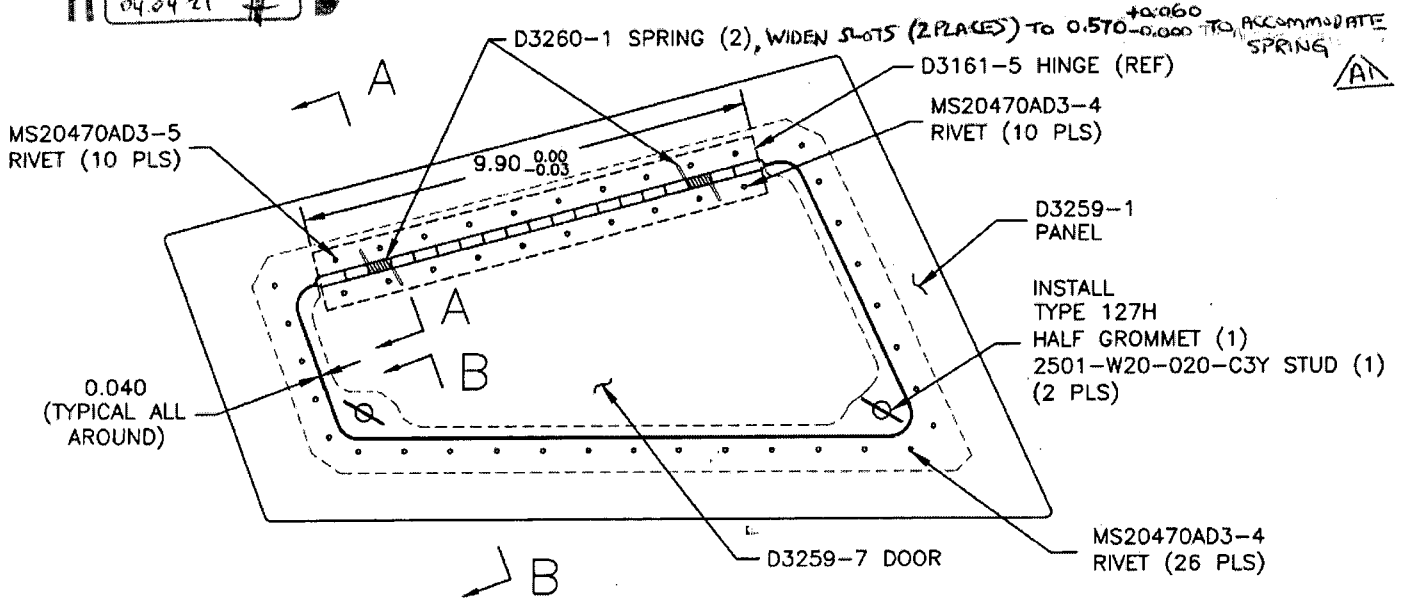
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | | | |
|---------|---------------|--|-----------------------|-----------------------------|--------------|
| DESIGN | RF | DRAWN BY | UP | DART AEROSPACE LTD | |
| | | | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | # | APPROVED | # | DRAWING NO. | REV. A |
| | | | | D3259 | SHEET 1 OF 6 |
| DATE | 04.02.25 | TITLE | ACCESS PANEL ASSEMBLY | SCALE | 1:4 |
| A | 04.02.25 | NEW ISSUE | | | |
| A1 | UP # 04.08.11 | WIDEN SLOTS TO ALLOW OPERATION OF SPRING | | | |

RELEASED
04.04.21 #



SECTION B-B
VIEW ROTATED

SECTION A-A
VIEW ROTATED

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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NO 33677

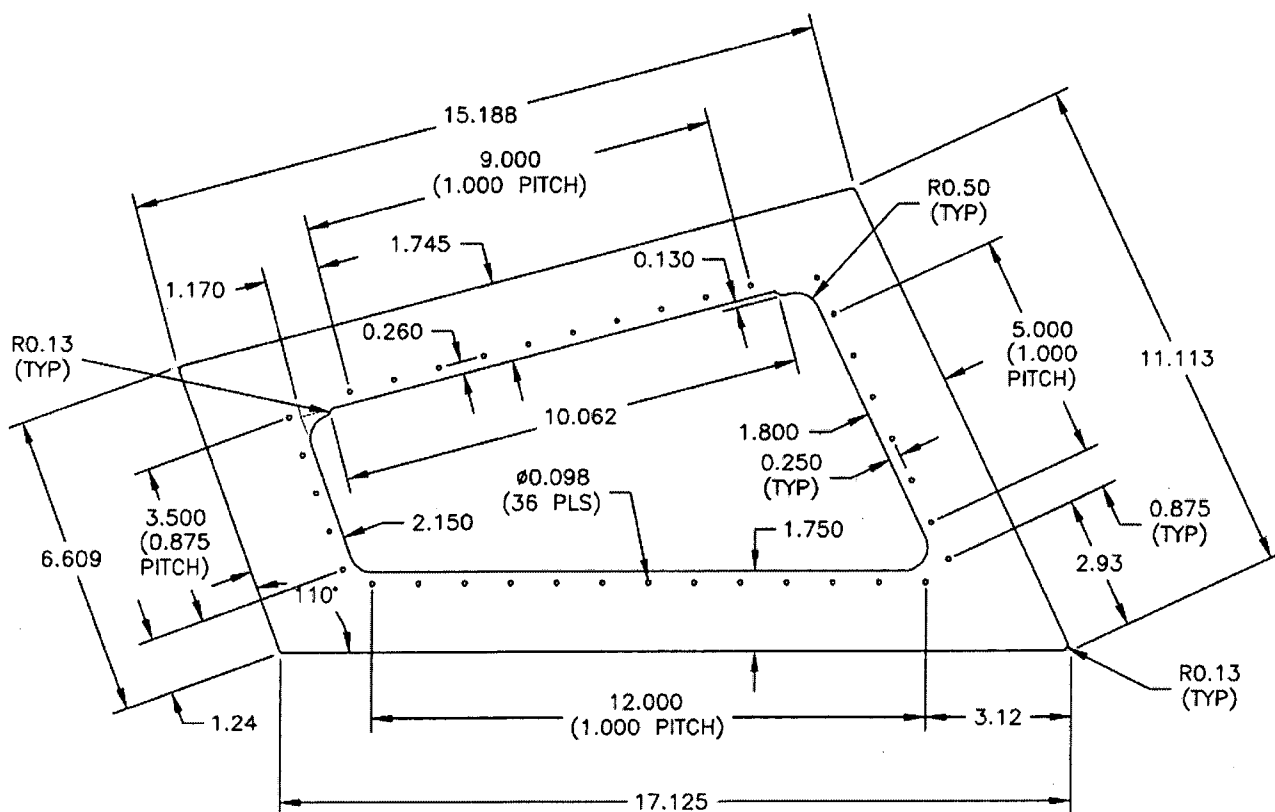
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| CHECKED # | APPROVED # | DRAWING NO. D3259 | REV. A SHEET 2 OF 6 |
| DATE 04.02.25 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:4 |

RELEASED
04.04.05



D3259-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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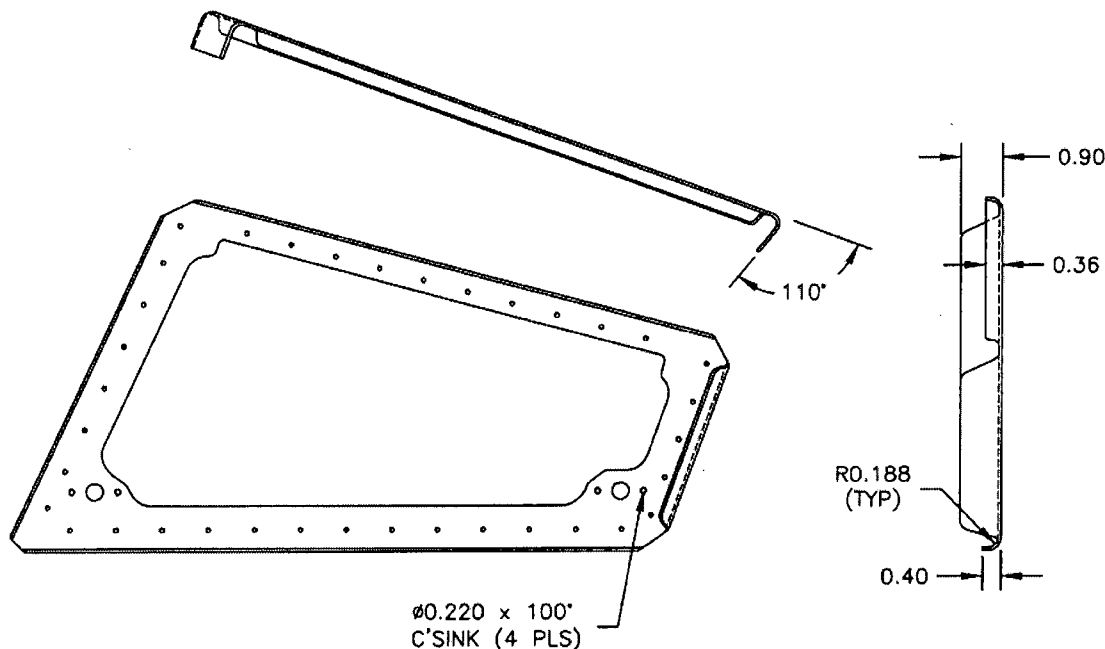
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| DATE 04.02.25 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:4 |

RELEASED
04.04.14



D3259-3 DOUBLER BEND DETAIL (SHOWN)

BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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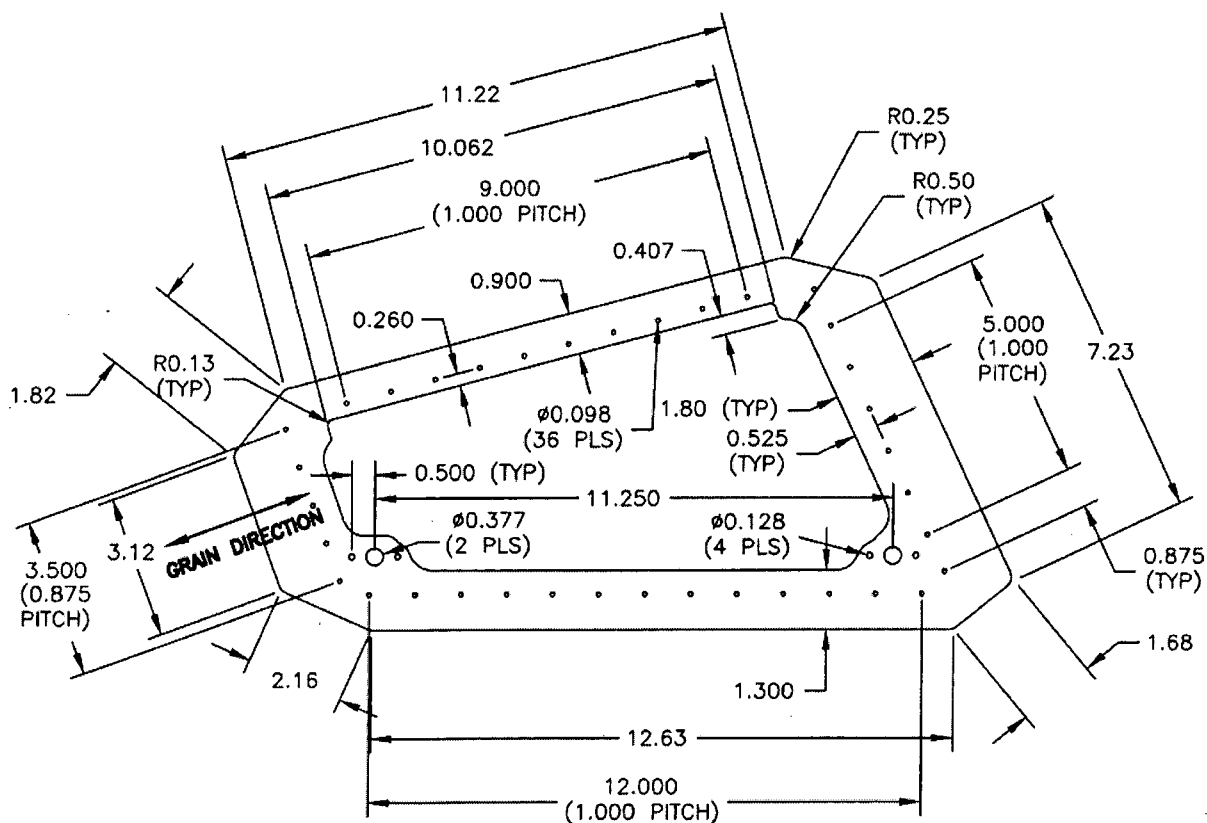
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|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3259 | REV. A SHEET 4 OF 6 |
| DATE 04.02.25 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:4 |

RELEASED
04.04.14 *[Signature]*



D3259-3/-4 DOUBLER FLAT PATTERN
($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

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NO. **33677**

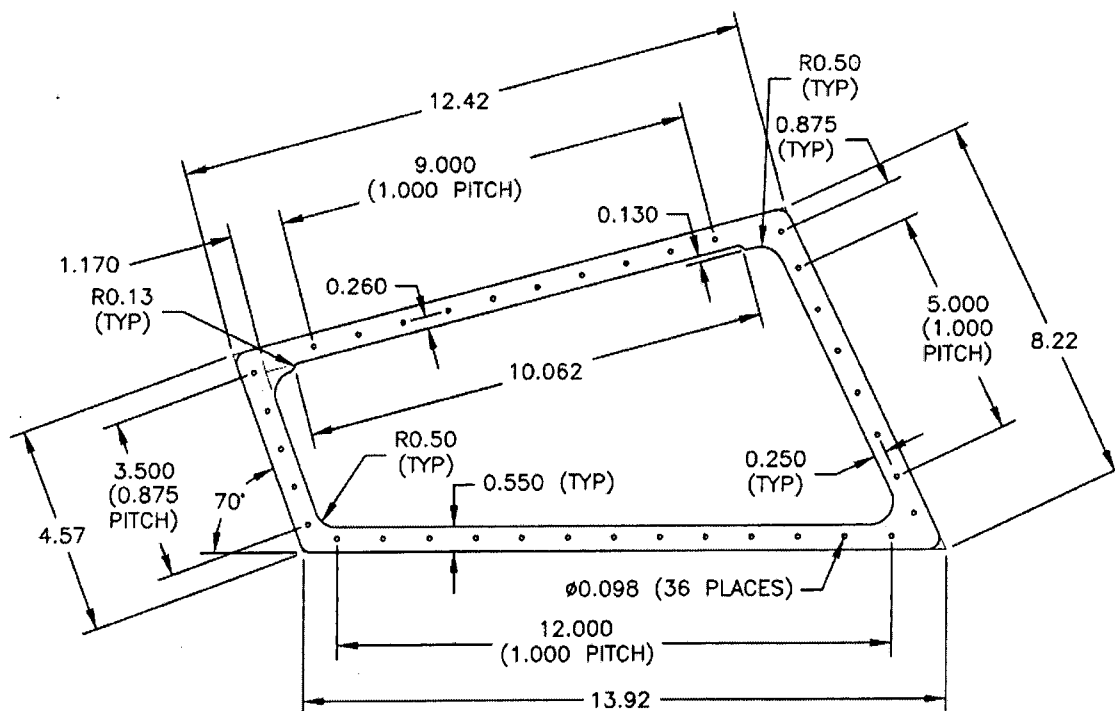
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| DATE 04.02.25 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:4 |

RELEASED
04.04.05



D3259-5 SPACER

(ϕ 0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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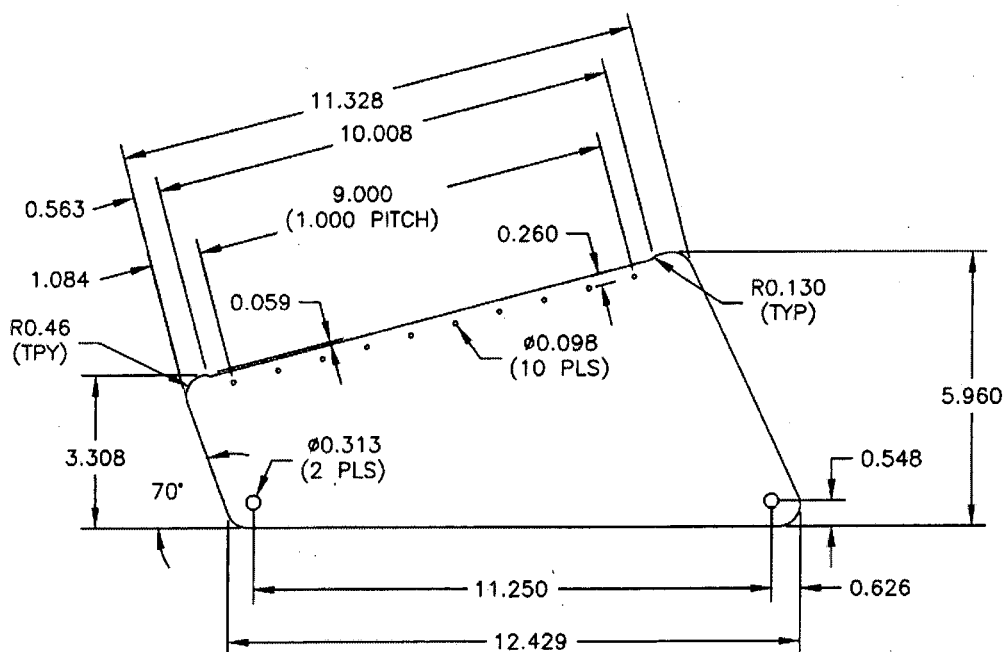
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| DATE 04.02.25 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:4 |

RELEASED
04-04-14



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 UNCONTROLLED COPY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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| | | | |
|--------------------|---------|--------------|----------|
| DART AEROSPACE LTD | | Work Order: | 33677 |
| Description: DOOR | | Part Number: | D 3259-1 |
| Inspection Dwg: | Rev: A1 | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø .313 | + .006 - .001 | .313 | X | | | |
| Ø .098 | + .004 - .001 | .099 | X | | | |
| 11.328 | +/- .010 | 11.328 | X | | | |
| 10.008 | +/- .010 | 10.008 | X | | | |
| 9.000 | +/- .010 | 9.000 | X | | | |
| 11.250 | +/- .010 | 11.250 | X | | | |
| 12.429 | +/- .010 | 12.429 | X | | | |
| 5.960 | +/- .010 | 5.960 | X | | | |
| 3.308 | +/- .010 | 3.308 | X | | | |
| .626 | +/- .010 | .626 | X | | | |
| .548 | +/- .010 | .548 | X | | | |
| 1.084 | +/- .010 | 1.084 | X | | | |
| .563 | +/- .010 | .563 | X | | | |
| .260 | +/- .010 | .260 | X | | | |
| .059 | +/- .010 | .059 | X | | | |
| R .130 | + | R .130 | X | | | |
| R .46 | | R .46 | X | | | |
| | | | | | | |
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|-----------------|----------------|---------------------|
| Measured by: JB | Audited by: E | Prototype Approval: |
| Date: 07-07-26 | Date: 07/07/26 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |